

**Work Order ID 71954**

Thursday, July 14, 2011 10:15:40 AM



Page 1

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile &amp; create labels per PPP D412-630-034 CHG003

S 11/07/14

J. J. CL 11-8-31

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14  
Coat all hardware with LPS3 rust inhibitor  
A/R LPS3 batch: 4109929  
COAT exposed HARDWARE WITH LPS PROCYON.  
A/R LPS PROCYON BATCH: M114596

E 11/08/31 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71954**

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Page 2

Item ID: D412-630-034

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Setup Start

Revision ID:

Stop

Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S wlog/31

x4  
RH

211/14/31 (4)

S wlog/14

x4  
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 71954**

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Page 3

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034 Location: _____ PPP Rev: <u>  A  </u>								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Thursday, July 14, 2011 10:15:47 AM




Page 1

\_\_\_\_\_

[illegible]**Required Date: 7/22/2011**

**Required Qty: 4.00**

**Comments:** IPP Rev:A New Issue 06-11-08 JLM  
 IPP rev B ecn1019, added D2807-041 EC verified by:DD  
 IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No			110	Each	33.0000	2	8		8/5/11/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				33					
					117771			23					
					118091			10					
AN3C21A  BOLT		Purchased	No			110	Each	77.0000	2	8		8/5/11/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				77					
					109148			7					
					117366			20					
					117514			50					
AN8C16  Bolt		Purchased	No			110	Each	37.0000	2	8		8/5/11/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST345				37					
					106066			37					

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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Thursday, July 14, 2011 10:15:47 AM

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2012-107

Manufactured No

110 Each

37.0000

1 4



Clevis

Location

Loc Qty

Loc Code

ST004

23

71602

23

WA005

14

66811

14

D2803-042

Manufactured No

110 Each

3.0000

1 4



Bracket Assembly

Location

Loc Qty

Loc Code

ST149

3

64093

1

71008

2

D2804-042

Manufactured No

110 Each

1.0000

1 4



Bracket Assembly

Location

Loc Qty

Loc Code

ST149

1

69400

1

D2807-041

Manufactured No

110 Each

19.0000

2 8



Door prop

Location

Loc Qty

Loc Code

ST022

11

60540

2

69671

9

ST023

8

68494

8

*ES 11/08/31*

*ES 11/08/31*

*ES 11/08/31*

*ES 11/08/31*

B72209 (34)  
B71008 (12)

B71005 (3x)  
B71566 (1x)

B71562 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2813  
Washer

Manufactured No

110 Each

41.0000

2

8

Location

Loc Qty

Loc Code

ST023

41

69386

21

71169

20

D3395-1  
Bushing

Manufactured No

110 Each

123.0000

4

16

Location

Loc Qty

Loc Code

ST052

123

69387

20

70775

40

71563

63

D3562-042  
Step Assembly, RH  
MS21043-3  
Nut

Manufactured No

110 Each

0.0000

1

4

B 71952

(4x)

Purchased No

110 Each

876.0000

4

16

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

804

112314

65

118077

739

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 14, 2011 10:15:47 AM

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

180.0000

2

8



Cotter Pin



8/5/11/08/31

Location

Loc Qty

Loc Code

ST357

180

117460

180

MS24693-C280

Purchased

No

110

Each

41.0000

2

8



Screw



8/5/11/08/31

Location

Loc Qty

Loc Code

ST310

40

115594

10

118093

30

ST318

1

111279

1

8

NAS1515H3

Purchased

No

110

Each

164.0000

6

24



Washer



8/5/11/08/31

Location

Loc Qty

Loc Code

ST277

164

116373

6

117460

58

118078

100

M118384 (24x)

NAS1515H5L

Purchased

No

110

Each

68.0000

4

16



WASHER



8/5/11/08/31

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

28

111359

28

M118378 (16x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 14, 2011 10:15:48 AM

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1515H8

Purchased

No

110

Each

227.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST278

227

111275

35

111411

192

130

Each

65.0000

1

4

AN44C7A

Purchased

No



Eyebolt

Location

Loc Qty

Loc Code

ST362

65

109013

25

111308

40

130

Each

73.0000

1

4

AN4C10A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST356

73

112243

43

114523

30

130

Each

93.0000

2

8

AN4C15A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST358

93

115835

11

117441

32

117795

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Thursday, July 14, 2011 10:15:48 AM

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

AN4C6A Purchased No

130 Each

298.0000

1

4



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

294

116704

19

117619

50

117794

50

117872

75

118191

100

117872

AN5C15A Purchased No

130 Each

117.0000

2

8



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

94

111819

4

117764

13

117885

25

118232

2

118267

50

117885

D2806-1 Manufactured No

130 Each

26.0000

2

8



Bushing

Location

Loc Qty

Loc Code

ST022

26

68492

6

70885

20

70885

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, July 14, 2011 10:15:48 AM

Page 7

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2806-3 Manufactured No

130 Each

27.0000

2

8



Bushing

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

130 Each

8.0000

1

4

D2810-5

Manufactured No



Strut

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

130 Each

38.0000

2

8

D3396-1

Manufactured No



Spacer

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

130 Each

696.0000

4

16

MS21043-4

Purchased No



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

656

117601

156

117793

500

Thursday, July 14, 2011 10:15:49 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Thursday, July 14, 2011 10:15:49 AM

Page 8

Work Order ID: 71954

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

567.0000

3

12



Nut

Location

Loc Qty

Loc Code

FG	20	
101418	20	
ST301	447	
112314	347	
116548	100	
ST314	100	
118159	100	

m112314

NAS1515H4

Purchased

No

130

Each

178.0000

7

28



Washer

Location

Loc Qty

Loc Code

ST277	178	
111525	2	
116169	3	
117460	50	
117735	75	
118078	48	

m117735

NAS1515H5

Purchased

No

130

Each

163.0000

7

28



Washer

Location

Loc Qty

Loc Code

FG	40	
103286	20	
103691	20	
ST277	123	
103286	100	
109430	23	

118384 P11/15/311(4)

Thursday, July 14, 2011 10:15:49 AM

Shop Packet Print

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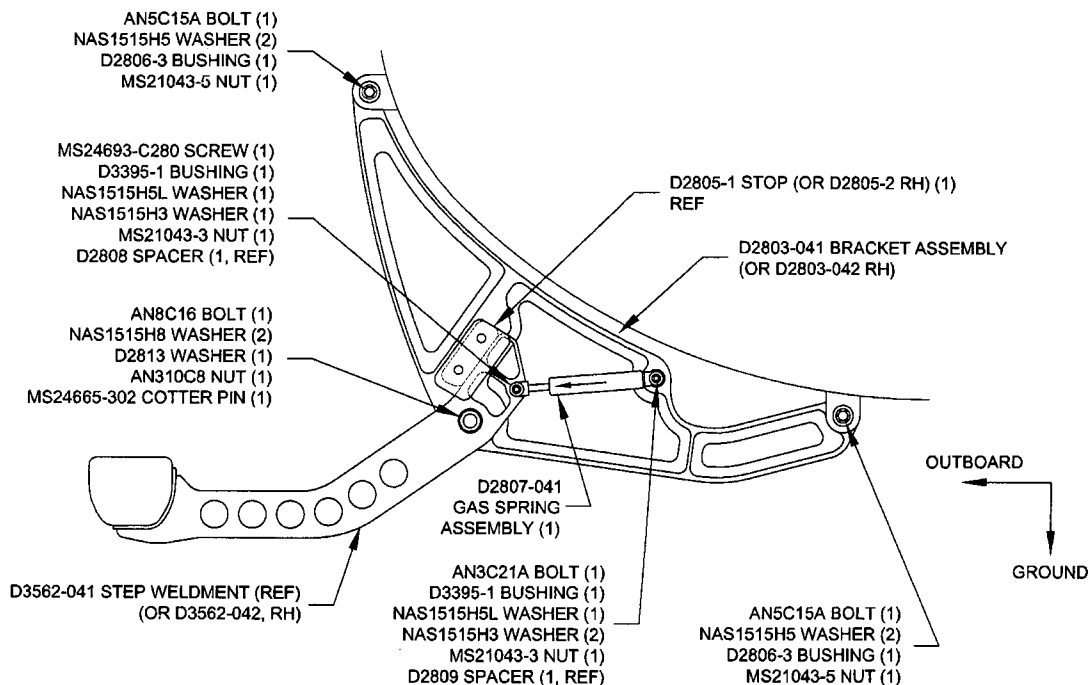
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

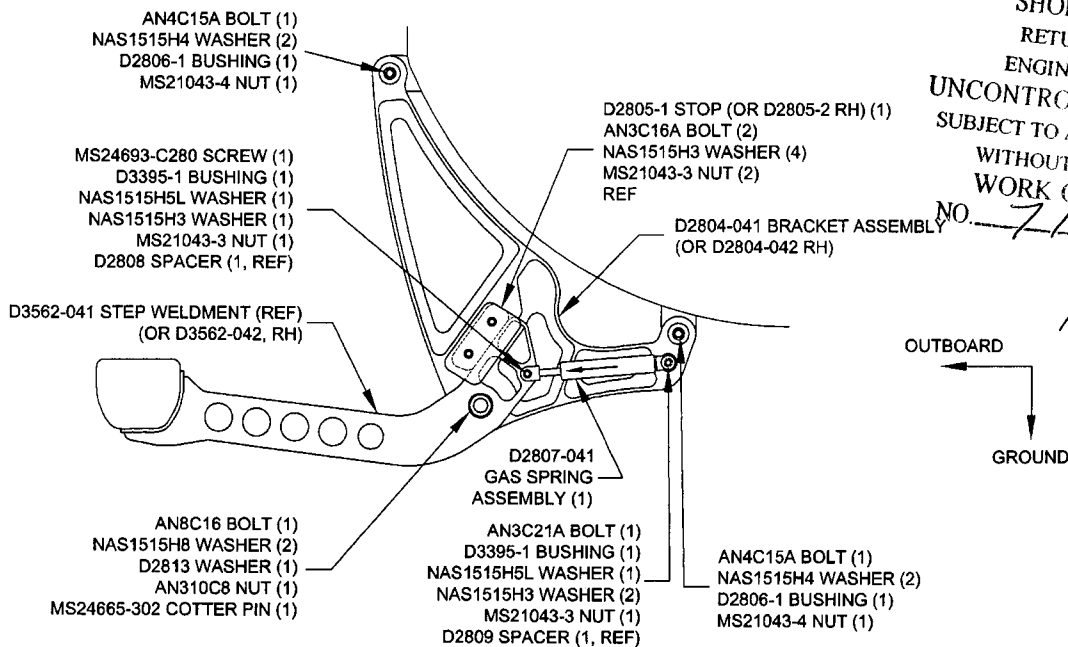
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71939

11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

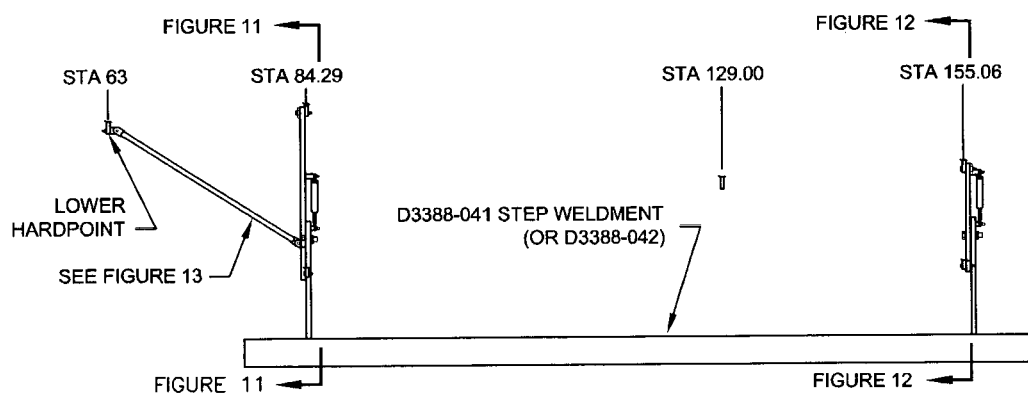
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

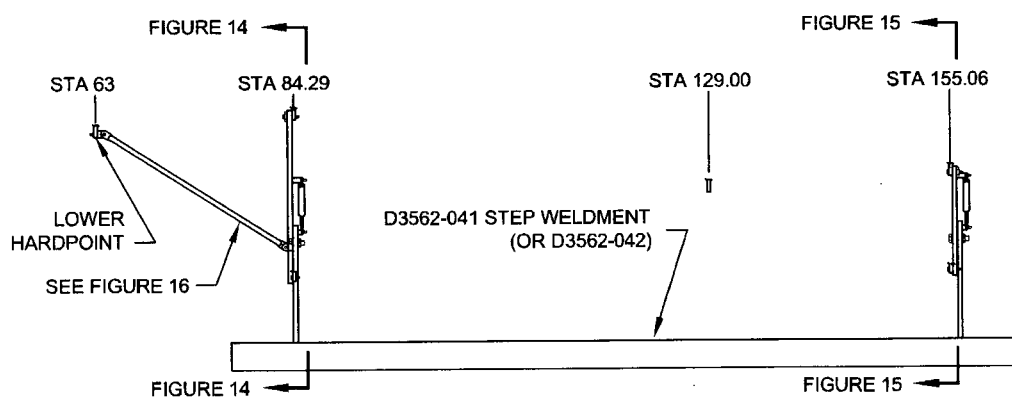
**NOTE:** Date & initial all entries



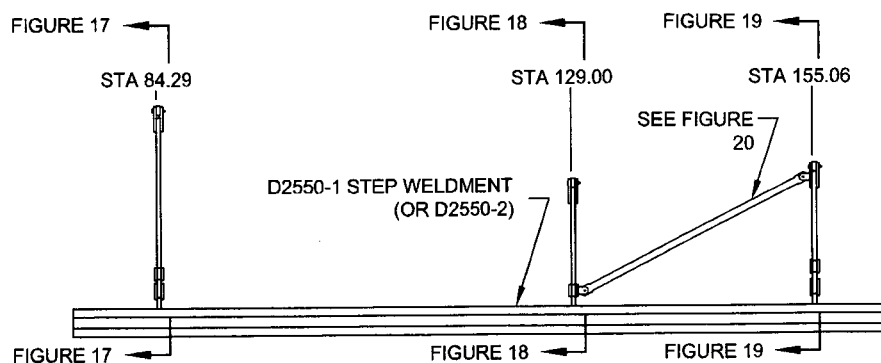
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)